

Flight Test Aug 16

ID 72668

04, 2011 2:43:11 PM



Page 1

D4417-011

Accept



Setup Start



Stop



Item Name: Q.R. Step Assembly (206L/407)

Start Date: 8/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-08-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4417

A/B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/8/108

120

0.00



HandFinish

Memo

0.00

Hand Finishing

ASSEMBLE AS PER DWG

EP 11/8/16 @

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulor 1/6

ASSEMBLY to Rev B

Drawn

@

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



Work Order ID 72668

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Item ID: D4417-011 Accept  Setup Start 
Revision ID:
Item Name: Q.R. Step Assembly (206L/407) Stop 
Start Date: 8/4/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 8/8/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210  Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
220  QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
Packaging									
Quality Control									

used on w/o 72858 W

11/8/16 J

MF 11-08-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 72668

Parent Item: D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)






Start Date: 8/4/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4417-041  Step Assembly		Manufactured	No				Each	0.0000					
D4418-1  Step Lug		Manufactured	No				Each	0.0000					
D2570  Bushing		Manufactured	No				Each	272.0000					
<div> <div>Location</div> <div>ST017</div> <div>66933</div> <div>67759</div> <div>71832</div> <div>72122</div> </div> <div> <div>Loc Qty</div> <div>272</div> <div>1</div> <div>6</div> <div>96</div> <div>169</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>													
D2690-5  Lanyard Assembly		Manufactured	No				Each	29.0000					
<div> <div>Location</div> <div>ST020</div> <div>70390</div> </div> <div> <div>Loc Qty</div> <div>29</div> <div>29</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
AN4C16A  BOLT		Purchased	No				Each	56.0000					
<div> <div>Location</div> <div>ST358</div> <div>117441</div> </div> <div> <div>Loc Qty</div> <div>56</div> <div>56</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

B 72669 (1P)

1
8/14/08/16

2
372670 SL

4
SL

4
3P

2
4/8/11 SL

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 72668

Parent Item: D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 8/4/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

AN4C36A Purchased No

Each 50.0000



Bolt



2
SP

Location

Loc Qty

Loc Code

ST360

50

118518

50

Each

8.0000

MS17984-C415

Purchased No



Pin, Quick Release



2
SP

Location

Loc Qty

Loc Code

ST315

8

118352

8

Each

1,057.000

MS21043-4

Purchased No



Nut



4
SP

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1017

117601

31

117793

486

118378

500

D4428-1

Manufactured No



Bushing



2
B72671 SP 11/8/16

Location

Loc Qty

Loc Code

ST

2

72555

2

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 72668

Parent Item: D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 8/4/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

Each

4,800.000



8
WHLG

Washer

Location

Loc Qty

Loc Code

ST297

4800

116900

182

117291

4618

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

11
3

1
2/2/68

8 7 6 5 4 3 2 1

D

C

B

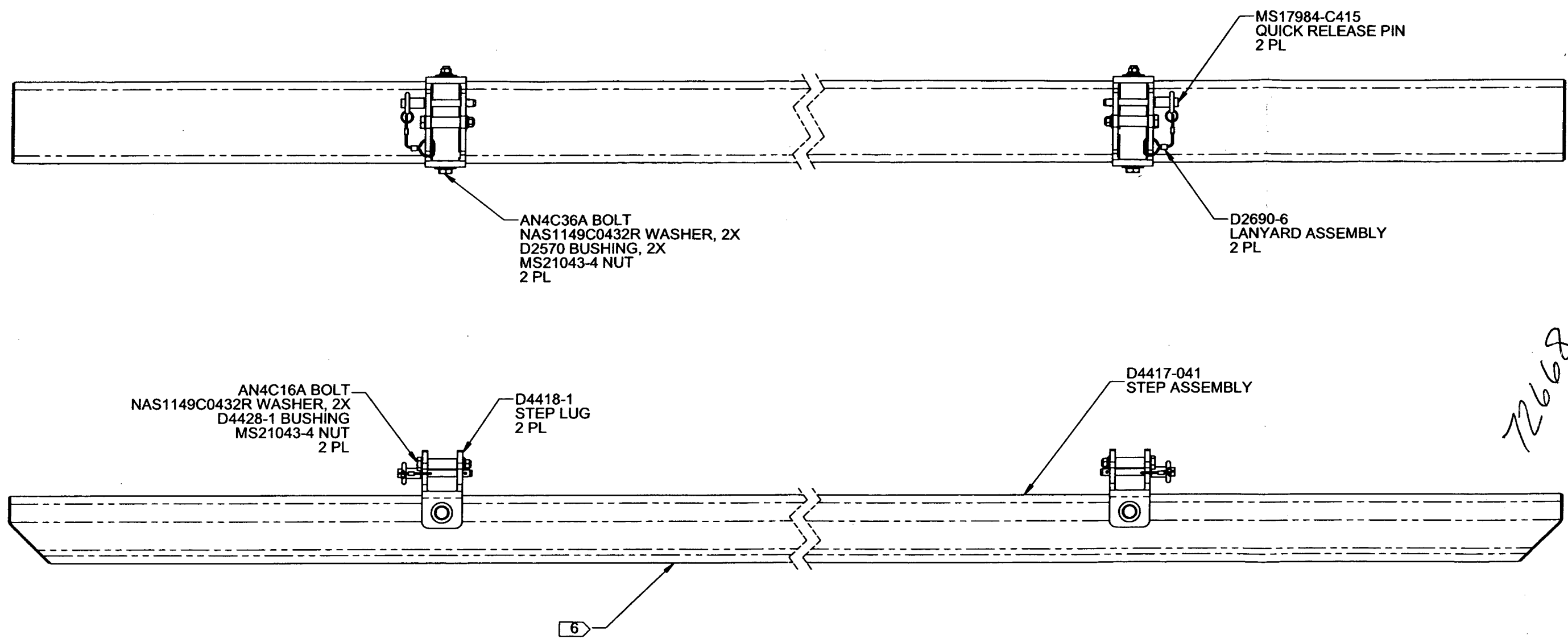
A

D

C

B

A



6

D4417-011 206L / 407 Q.R. STEP ASSEMBLY

RELEASED
2011-08-02
MP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4417-011" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
 - 7) WEIGHT: 8.75 lbs

DESIGN	A/S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A/S		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4417	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206L / 407 Q.R. STEP ASSEMBLY	NTS
DATE	11.07.28	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

